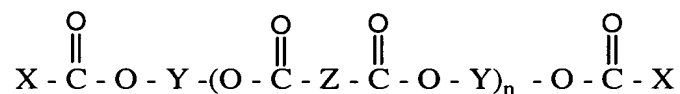


Amendments to the Claims:

The following claims will replace all prior versions of the claims in this application (in the unlikely event that no claims follow herein, the previously pending claims will remain):

1-18. (Cancelled).

19. (Currently amended) A metal working fluid comprising an ester according to the formula:



wherein

X is an aliphatic hydrocarbyl group having 5-11 carbon atoms;

Y is an alkylene group having 4-6 carbon atoms;

Z is an a saturated linear aliphatic hydrocarbyl group having 4 carbon atoms
and

n is a weight average number between + 1.5 and 10.

20. (Cancelled).

21. (Previously presented) The metal working fluid of claim 19 further comprising an oil selected from a mineral oil, a vegetable oil, or an animal oil.

22. (Previously presented) The metal working fluid of claim 19 further comprising a surfactant.

23. (Previously presented) The metal working fluid of claim 19 further comprising an emulsifier.

24. (Previously presented) The metal working fluid of claim 19 further comprising a corrosion inhibitor.

25. (Previously presented) The metal working fluid of claim 19 further comprising water.

26. (Previously presented) The metal working fluid of claim 19 further comprising a metal deactivator.

27. (Previously presented) The metal working fluid of claim 19 further comprising an anti-foam agent.

28. (Previously presented) The metal working fluid of claim 19 further comprising an anti-oxidant.

29. (Previously presented) The metal working fluid of claim 19 having a kinematic viscosity at 100°C less than 20mm²/s and a kinematic viscosity at 40°C of less than 150mm²/s.